

Date: Wednesday, 10/24/2007 7:31:53 AM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 35338		
Estimate Number	: 10641		
P.O. Number	: N/A	Part Number	: D314415
This Issue	: 10/24/2007 S.O. No. : N/A	Drawing Number	: D3144 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 10/24/2007	Drawing Revision	: C
Previous Run	: 24724	Material	: N/A
Written By	<i>JL 07-10-24</i>		
Checked & Approved By			
Comment	: Est. A 05.11.03 New issue KJ/RF		

Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
		

Comment: Qty.: 0.3330 sf(s)/Unit Total : 1.9980 sf(s)
2024-T3 .032 sheet
Batch: <i>105555</i> <i>1B07-10-24</i>

2.0	WATER JET	FLOW WATER JET
		

Comment: FLOW WATER JET
1-Cut as per Dwg D3144
Dwg Rev: <i>C</i> <i>1B07-10-24</i>
Prog Rev: <i>C</i>
2-Deburr if necessary <i>1B07-10-24</i>


3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	<i>1B07-10-24</i>	

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
		
	<i>S 07/10/24 X(5) counter</i>	

Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
	<i>15X</i>	

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1
<i>m-f 07/10/24</i>

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 35338

Part Number: D314415

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 POWDER COATING

POWDER COATING



M102316



(15)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BR 07-10-24

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



C20710124

(15)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST150

C207102115

(15)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



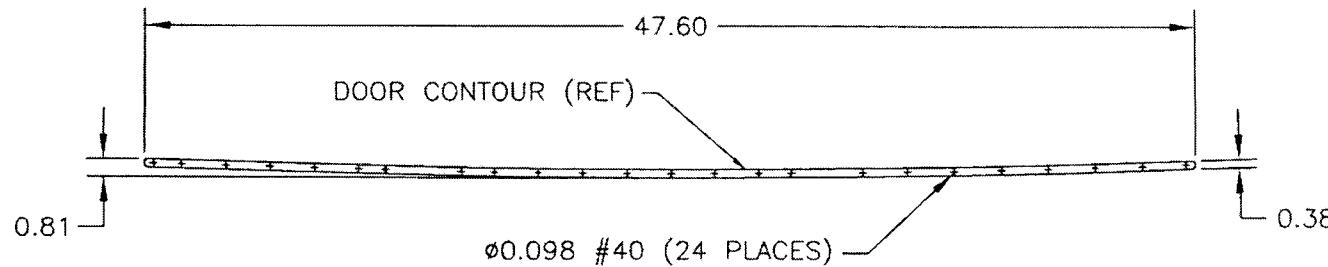
Comment: FINAL INSPECTION/W/O RELEASE

D20710124

Job Completion



C20710124



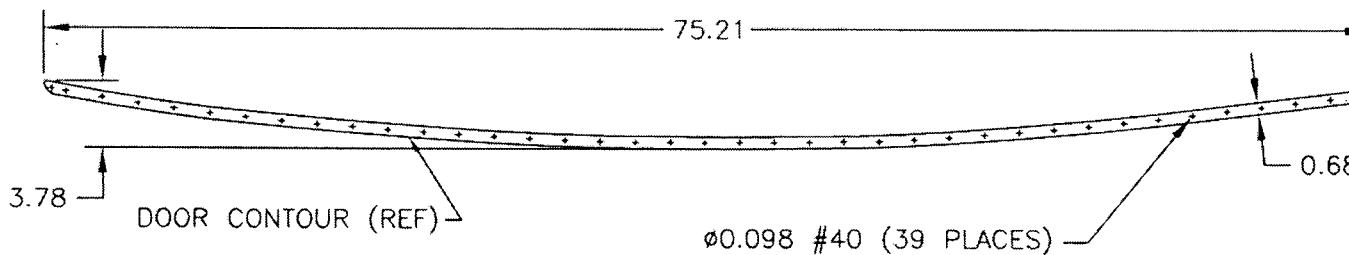
D3144-15 DOUBLER
SCALE 1:8



RELEASED

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	REV. C
DATE 05.10.19	TITLE DOUBLER	DRAWING NO. D3144	SHEET 4 OF 9



D3144-13 DOUBLER
SCALE 1:10

REPLACES PREMIER P/N B30-23000-211

D3144-13 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

BART AEROSPACE LTD	Work Order:	35338
Description: Doubler	Part Number:	D 3144-15
Inspection Dwg: D 3144-15 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	u/s
Date:	07-10-24	Date:	07/10/24	Date:	/ /

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	